

Date: Wednesday, 3/14/2007 3:27:54 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 204 STEP LUG	
Job Number	: 31210				
Estimate Number	: 11844				
P.O. Number	: N/A		Part Number	: D23382	
This Issue	: 3/14/2007	S.O. No.	: N/A	Drawing Number	: D2338 REV B U/R
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: 3/14/2007	Type	: MACHINED PARTS	Drawing Revision	: B
Previous Run	:		Material	: N/A	
Written By	:		Due Date	: 3/23/2007	
Checked & Approved By	:		Qty:	6 Um: Each	
Comment	: Est. B00.03.24 Separated -1 from -2 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000 	6061-T6 Bar .50" x 6.0" 
	Comment: Qty.: 0.3827 f(s)/Unit Total : 2.2964 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 0.5 x 6.0" Batch: <u>7103436</u>	<i>JK 07/03/19</i>
2.0	BAND SAW 	BAND SAW 
	Comment: BAND SAW Cut Blanks 8.75" long	<i>JK 07/03/19</i>
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2338 Tumble & Deburr	<i>SD / JK 07/03/19</i>
4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SD / 07.03.20</i>
5.0	QC8 	SECOND CHECK 
	Comment: SECOND CHECK	<i>J.F. 07/03/20 ⑥</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/3/22 (6)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



07/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31210
Description: 204 Step Lugs	Part Number:	D2338-2
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A						
B						
C						
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SA	Audited by: JF	Prototype Approval: N/A
Date: 07-03-20	Date: 07/03/20	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	